Date: Monday, 4/23/2007 3:41:43 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: LUG BRACKET
Job Number	: 32018B		
Estimate Number	: 10339		
P.O. Number	: N/A	**Part Number**	: D2658
This Issue	: 4/23/2007 **S.O. No.** : N/A	**Drawing Number**	: D2658 REV D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: D
Previous Run	: 29780B	**Material**	: N/A
Written By	:	**Due Date**	: 5/18/2007 **Qty:** 30 **Um:** Each
Checked & Approved By	: 07.04.23		
Comment	: Est Rev:A New Issue 05-11-07 JLM		
	Est Rev:B Now on Waterjet 06-08-23 JLM		

33
30

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M1010S12GA	1010/1025/A21/6aA SHEET

Comment: Qty.: 0.1197 sf(s)/Unit Total : 36.0297 sf(s) 3.9501
1010/1025/A21/6aA SHEET
12 GAUGE .100" THK
Batch: M104288 SAD 07/06/12 33

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D2858
Dwg Rev: D
Prog Rev: D
2-Deburr if necessary G.A 07.06.18 SAD 07/06/12 33

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/06/12 33

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK Er 07/06/18 x33

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
1-Deburr as required.
2-Bend on CNC brake using DT8254Identify as D2658 SB 07/06/18 33

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ☐ **Date:** 8/16/25

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LUG BRACKET

Job Number: 32018B **Part Number:** D2658

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/06/18
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WS	07/06/25 33
8.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	33 07/06/25

Job Completion

07/06/25

Form: mprocess

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32018B
Description: Lug Bracket	Part Number:	D2658
Inspection Dwg: D2658 **Rev:** D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00	✓		Vern	
2.500	+/-0.010	2.500	✓		Vern	
5.205	+/-0.010	5.209	✓		Vern	
Ø0.313	+0.006/-0.001	Ø0.315	✓		Vern	
0.100	+/-0.010	0.101	✓		Vern	

Measured by:	SAM
Date:	07/06/12

Audited by:	
Date:	07/06/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.13	New Issue	KJ/JLM	

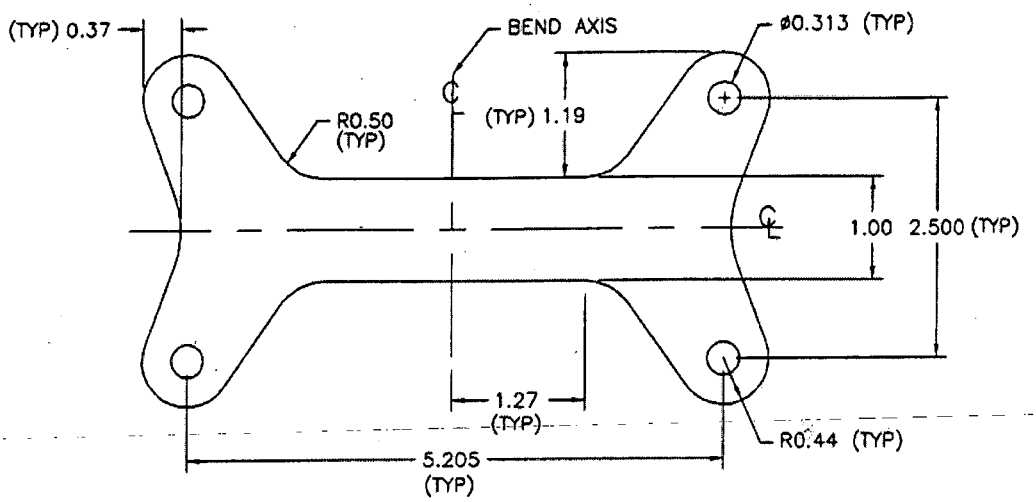
DART

COPY ISSUED

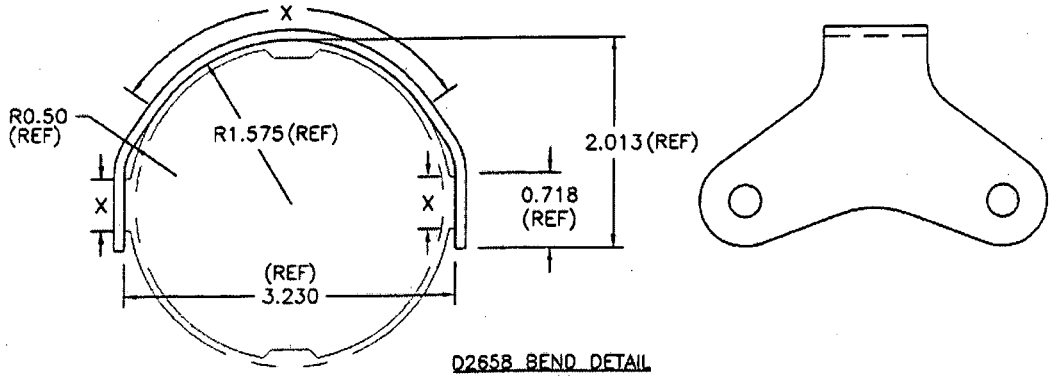
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED GP	APPROVED KE	DRAWING NO. D2658 REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET SCALE 5:9

A	97.11.03	NEW ISSUE
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE
C	98.10.23	UPDATE MATERIAL (TSR A1114)
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (℄)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 32018 B